

Work Order ID 50352

July 13, 2009 11:59:52 AM



Page 1

Item ID: D3407-5

Accept



Setup Start



Revision ID: E

Stop



Item Name: Ring

Start Date: 7/15/09

Start Qty: 14.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 14.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *09-07-15*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3407	Rev E

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3407 ☒ Dwg Rev: *E* ☐ Prog Rev: *E* ☐ 12-
Break edges on grinder as per Dwg D3407

Debur m. 09/08/05

IB 9-7-31

(20X)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

IB 9-7-31

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

2) Scrolos

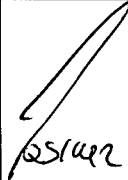
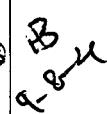




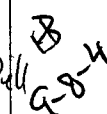

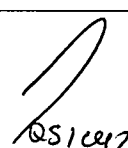

cut
(20X)

(20X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3407-S PAR #: NA Fault Category: 3m fab NCR: Yes No DQA: NA Date: 09.08.01
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: NA Date: 09.08.17

NCR: <u>50352</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/7/31	100	After employee cut all Qty 420 parts he tried to pull the marks one he realizes it was 304 not 17-4.		SCRAP AND Destroy non conforming part. Qty 420 - can not be used for anything else. Replace 17-4 B <u>112331</u>				
	water set	R.C After he cut 304 last time he wrote the wrong material on L.O.A.		- Remind / Retrain employ @ water set to be more care full when using mat. I.Ding.				

NOTE: Date & initial all entries

Work Order ID 50352

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Page 2

Item ID: D3407-5

Accept



Setup Start



Revision ID: E

Stop



Item Name: Ring

Start Date: 7/15/09

Start Qty: 14.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 14.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: W/A

0.00



Packaging

Memo

Lank Beeth

0.00

EL

9-8-5

20

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u 9-8-5

05-08-09
NA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 50352



Parent Item: D3407-5RevE



Parent Item Name: Ring

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 14.00

Required Qty: 14.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M174B0.250X4.000		Purchased	No			100	f	13.9217	3.9288			
17-4 SS Bar .250 X 4.00												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

13.92168421

110630

1.92168421

111699

12

105358

18 9-7-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	50352
Description: Tow Ring		Part Number:	D3407-5
Inspection Dwg: D3407 Rev: E		Page 1 of 1	

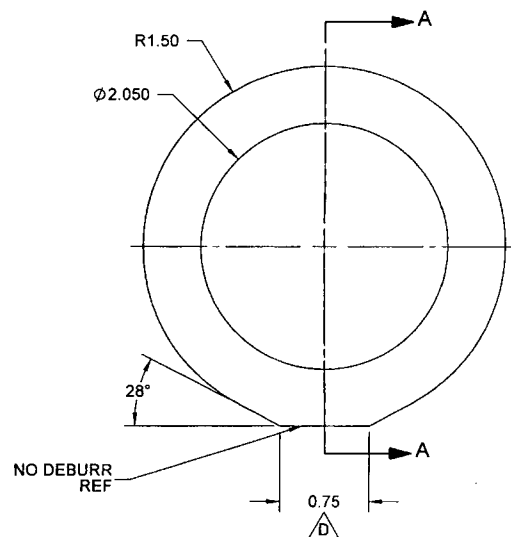
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

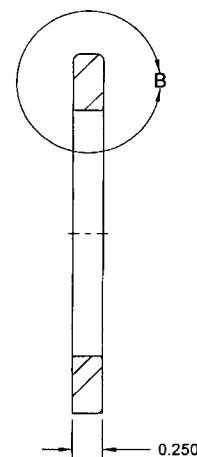
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	0.244	*			
Ø3.000	+/-0.030	2.994	*			
Ø2.050	+0.012/-0.001	2.054	*			
0.75	+/-0.030	0.755	*			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 9-7-31	Date: 09/08/05	Date:	N/A

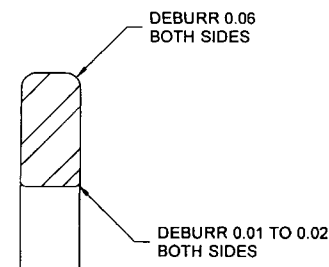
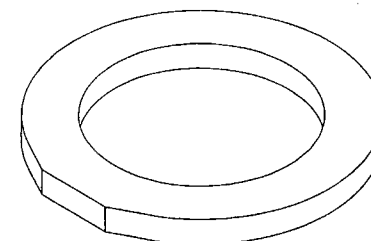
Rev	Date	Change	Revised by	Approved
A	07.02.02	New Issue	KJ/JLM	
B	07.09.18	Tolerance revised	KJ/EC	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	09.05.04	Dwg Rev updated	KJ/DD	



D3407-5 RING



SECTION A-A



**DETAIL B
SCALE 2X**

RELEASED
08-06-01/10

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50352

mf 09-07-15

DESIGN	97	DART AEROSPACE USA, INC.	
DRAWN	1/81	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	